

April-13-12 8:29:47 AM

ASAP

83125

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 13/04/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 20/04/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MCS*

Date: 12/04/13 Tooling:

Date:

Run Start *NR1*

QC:

Date: / / **SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

W/O: 83125

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4617-045 PAR #: _____ Fault Category: Low / Special Projects NCR: Yes ☐ No ☒ DQA: [Signature] Date: 12/05/04
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: _____ Date: _____

NCR: 12-1412

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/04	#120	Duminy trail EF Parts get marked, moved, & scratched. R.C. Process	S 12/05/04 Q57042	Disassemble clamp.	FF 12-05-02	S 12/05/04	S 12/05/04 Q57042	S 12/05/04
				Re Buff out all marks	FF 12-05-02			
				Re Assembly As per Q57005	12-05-02 FF			
				Re Assembly - AN4-14A-M121243 (12x) MS 210 44N4-M121464 (12x) NAS 1149C0463R-M119097 (12x)	FF 12-05-02	S 12/05/04	S 12/05/04 Q57042	S 12/05/04

NOTE: Date & initial all entries

Work Order ID 83125

83125

Page 2

April-13-12 8:29:47 AM

Item ID: D4617-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp Assembly

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
130						<i>(4)</i>			<i>8/12/05/07</i>
Packaging	Memo <i>W/O 83120</i>	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/5/17

1205-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 8:29:50 AM

Page 1

Work Order ID: 83125

83125

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 13/04/2012

Required Date: 20/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.04.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A

Purchased

No

100

Each

391.0000

3

12

AN4-14A

Bolt

**

(4)

FF 12-04-30

Location

Loc Qty

Loc Code

357

100

121349

100

ST357

291

120187

13

120769

1

121068

77

121162

100

121243

100

12

D4617-5

Manufactured

No

100

Each

0.0000

1

4

D4617-5

Clamp Body

B 83128

**

4

(4)

FF 12-04-30

D4617-7

Manufactured

No

100

Each

0.0000

1

4

D4617-7

Clamp Half

B 83123

**

4

(4)

FF 12-04-30

MS21044N4

Purchased

No

100

Each

0.0000

3

12

MS21044N4

Nut

M 121464

**

12

(4)

FF 12-04-30

MS22034-4

Purchased

No

100

Each

1.0000

1

4

MS22034-4

FOOT

**

4

(4)

FF 12-04-30

Location

Loc Qty

Loc Code

ST304

120559

1

116717

1

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April-13-12 8:29:50 AM

Page 2

Work Order ID: 83125

83125

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 13/04/2012

Required Date: 20/04/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0463R

Purchased

No

100

Each

967.0000

3

12

NAS1149C0463R

(4)

FF12-04-30

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

966

117735

25

119097

941

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP

D4617-045
CLAMP ASSEMBLY
4 PL

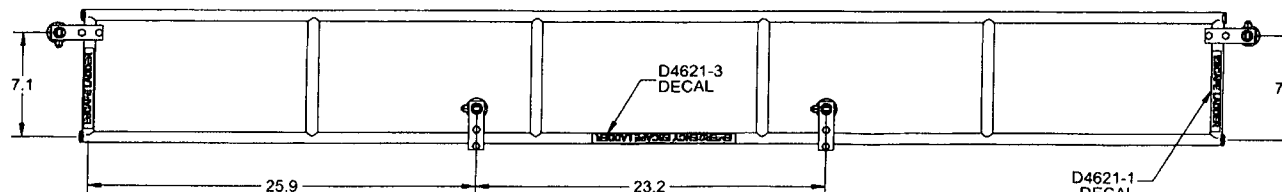
D4618-041
CLAMP ASSY COVER
4 PL
(SHOWN REMOVED THIS LOCATION)

D4617-043
LADDER WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83125 *mcj*
12/04/13

D4625-1
TUBE CAP
4 PL

(CLAMP ASSY COVERS REMOVED FOR CLARITY)



D4617-041 EMERGENCY ESCAPE LADDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.46 lbs

A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AV	DRAWING NO.	REV. A
MFG. APPR.	AV	D4617	SHEET 1 OF 5
APPROVED	AV	TITLE	SCALE
DE APPR.	AV	EMERGENCY ESCAPE LADDER	NTS
DATE	12.04.02	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

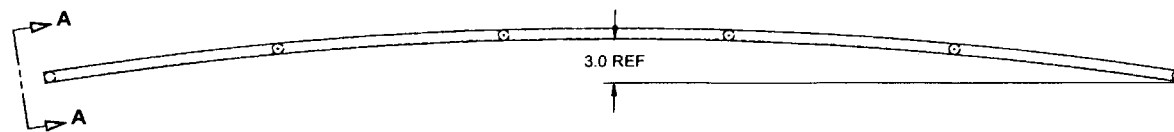
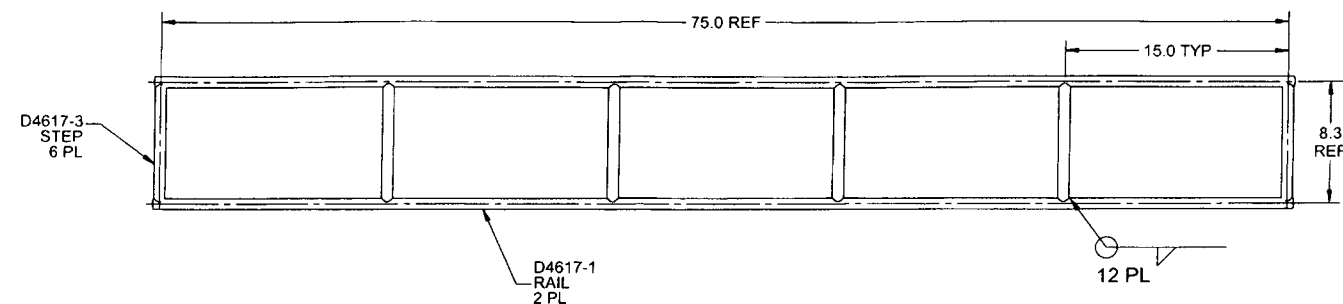
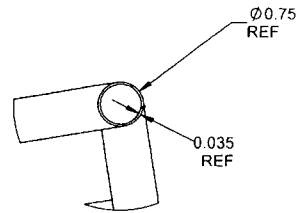
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83125



D4617-043 LADDER WELDMENT

RELEASED
2012-04-10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

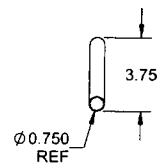
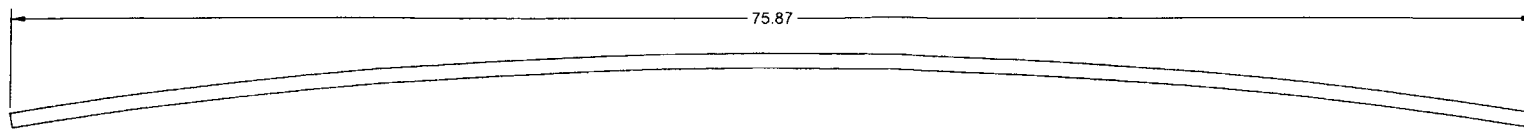
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

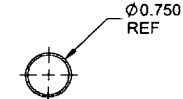
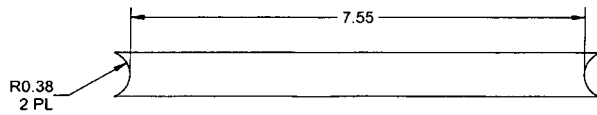
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83125



D4617-1 RAIL



D4617-3 STEP

RELEASED
2012-04-18

NOTES:

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

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CHECKED	A.R.	DRAWING NO.	REV. A
MFG. APPR.		D4617	SHEET 3 OF 5
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

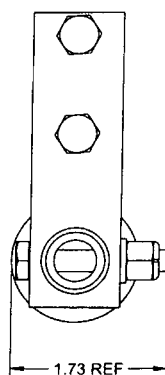
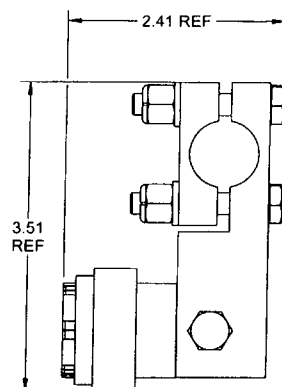
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

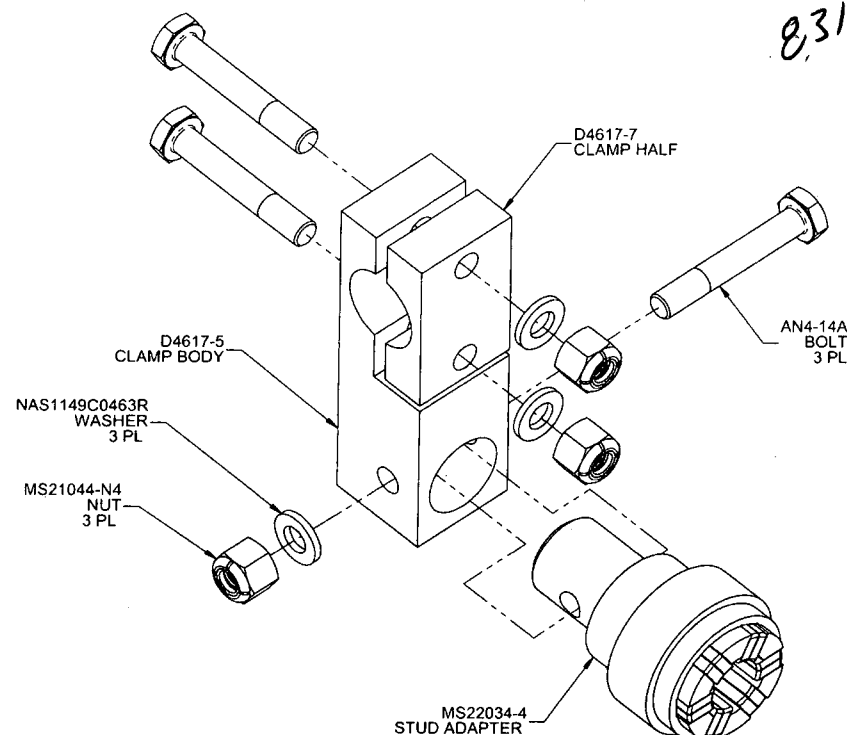
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	3	MS21044-N4	NUT
5	1	MS22034-4	STUD ADAPTER
6	3	NAS1149C0463R	WASHER



D4617-045 CLAMP ASSY



- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: PER DART QSI044 6.6
 7) WEIGHT: 0.5 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RP	DRAWING NO. D4617	REV. A
MFG. APPR.			SHEET 4 OF 5
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DATE	12.04.02		

RELEASED
 2012-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

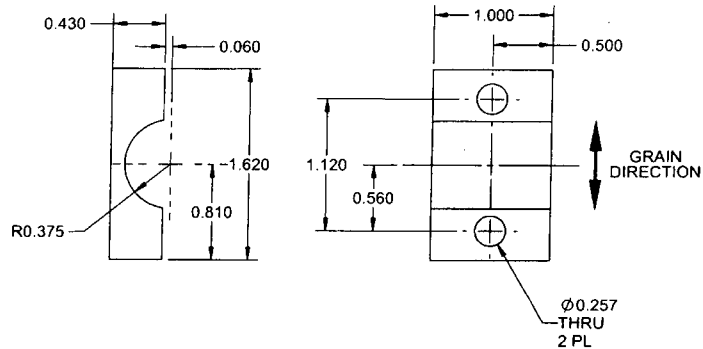
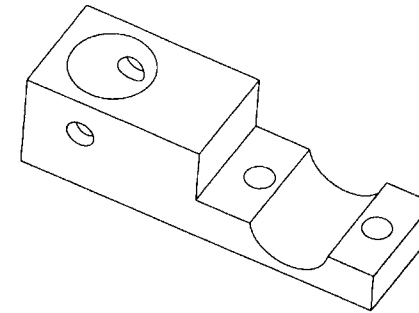
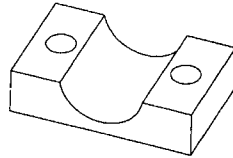
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

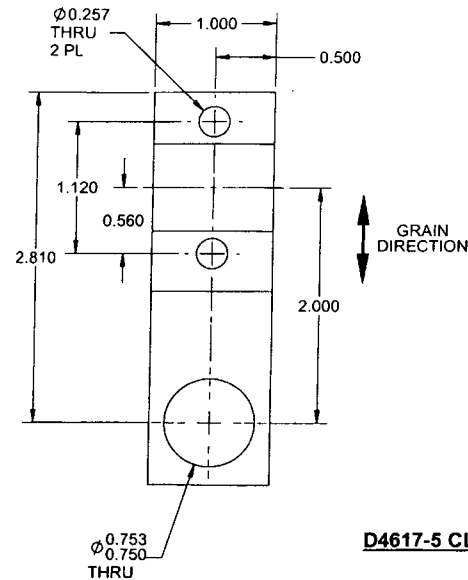
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83125



D4617-7 CLAMP HALF



D4617-5 CLAMP BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N-212-110-06
D4617-7: EAGLE P/N 212-110-07

RELEASED
2012-04-10

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4617	SHEET 5 OF 5
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DE APPR.		EMERGENCY ESCAPE LADDER	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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